

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013389**Date Inspected:** 25-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG Segment 9BW		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) - Document: 005413

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 9BW. The weld designations reviewed are as follows:

1. SEG051A-031, 032
2. SEG051A-001, 002, 003
3. SEG051\*-0031, 032, 033, 035
4. SEG051\*-001, 002, 003, 004
5. SEG051\*-007, 008, 006, 014, 019, 020

Ultrasonic Testing (UT) - Document: 005416

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 9AE. The weld designations reviewed are as follows:

---

## WELDING INSPECTION REPORT

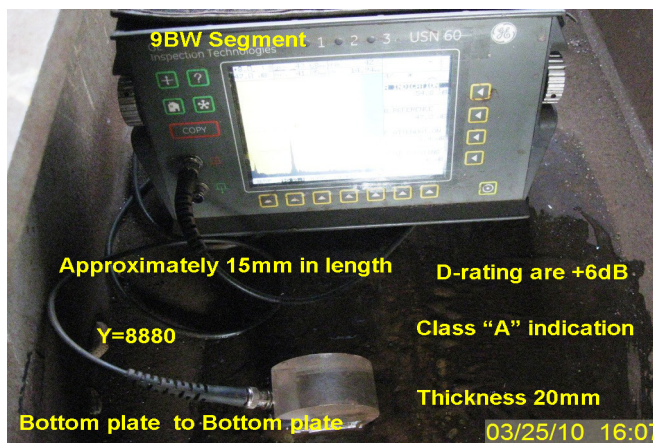
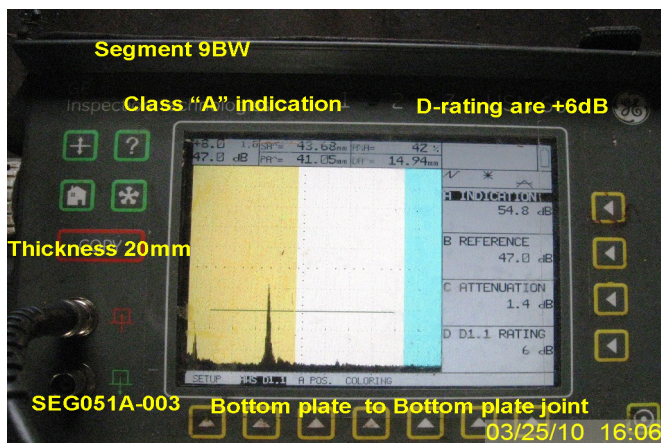
( Continued Page 2 of 2 )

---

1. SEG0051A-003

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Segment 9BW, this Quality Assurance Inspector (QA) discovered two (2) Class “A” indication measuring approximately 15mm in length. The indications D-rating are +6dB each and the weld joint is identified as SEG051A-003. The weld is a Complete Joint Penetration (CJP) butt weld joining Bottom plate BP95A is identified as PL739A to Bottom plate BP44A is identified as PL715A. The Thickness of the Bottom plate is 20mm. The “Y” locations are approximately 2360 and 8880 mm from one edge of the bottom plate PP76 East Side. The indications are clearly marked by QA on/near the weld. This weld joint is designated as Seismic performance critical weld member (SPCM). The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform 100% UT inspection of this weld.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

---

**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

---

**Reviewed By:** McClendon,Timothy

QA Reviewer